

Date: Wednesday, 21/01/2009 7:38:05 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 44986		
Estimate Number	: 13421		
P.O. Number	:	Part Number	: PB6743001239
This Issue	: 21/01/2009 S.O. No. :	Drawing Number	: B6743001 P.6/ P.21
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 41917	Material	:
Written By	:	Due Date	: 27/01/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>MF 09-01-21</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W120	6061T6 SQ TUBE 1.00 x 1.00 X .120w
	Comment: Qty.: 1.8375 f(s)/Unit . Total: 22.0500 f(s) 6061T6 SQ TUBE 1.00X.120 batch: <u>M109928</u>	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1  1- cut to length as per dwg 2- make a 0.090" chamfer on both ends of tube 3- deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE 1- drill holes as per dwg 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes 3- deburr	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 44986

Part Number: PB6743001239

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Bushing

batch: 343711-25

344988-23

09-02-04

12

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Square Cap

batch: 344000

09-02-04

12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

09-02-04

12

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

09-02-04

12

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09/02/05 (12)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/05 (12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

09/02/05 (12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/06

MF 09-02-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

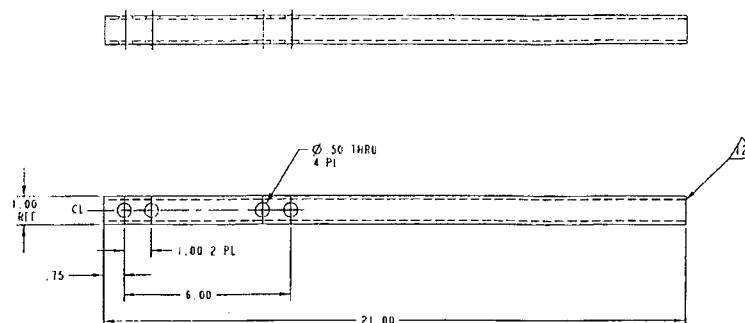
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

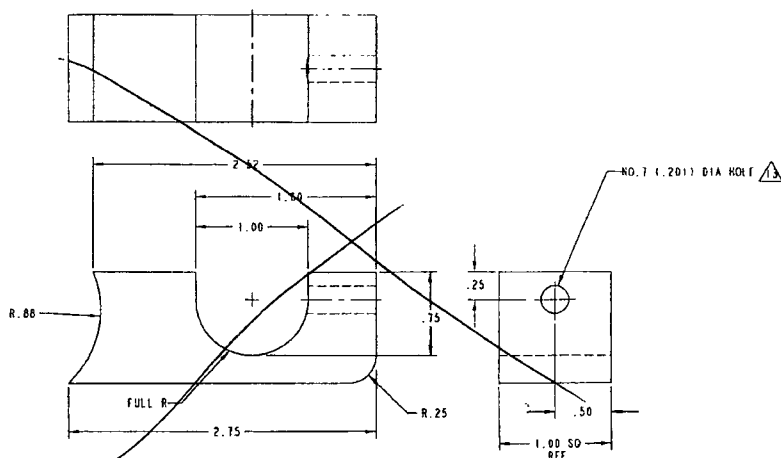
**NOTE:** Date & initial all entries

RELEASED  
406 of 20

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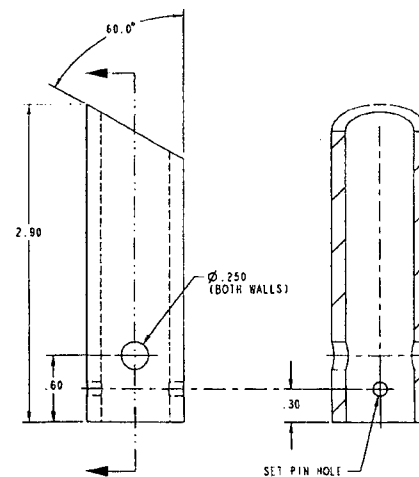
① -239 SQUARE TUBE   
MATL: 1.00 SQ X .125 WALL, 6061-T6  
QD-A-200/8  
SCALE 0.500



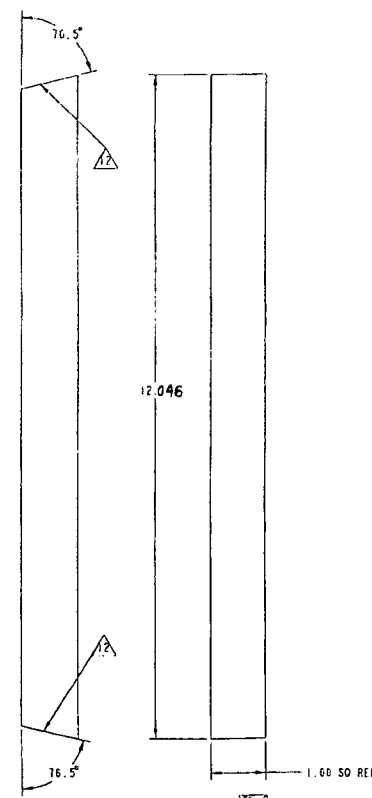
① -241 TUBE DETENT CLIP   
MATL: 1.00 SQ, 6061-T6  
QD-A-200/8  
SCALE 2.000

SUPERCEDED BY

① 23440-9



① -243 TUBE HANDLE EXTENSION   
MATL: .875 OD X .125 WALL, 6061-T6  
QD-A-200/8  
SCALE 2.000



① -139 SQUARE TUBE   
MATL: 1.00 SQ X .125 WALL, 6061-T6  
QD-A-200/8  
SCALE 1.000

PREMIER AVIATION, INC.  
3000 Aviation Parkway, Grand Prairie, Texas 75050  
DATE CODE REVISION NO. REV. NO.  
DLOSUV8 B67-43001 B1  
SHEET 21 OF 43

ORIGINAL

